

IN THE CLAIMS:

1. (Currently Amended) A method of producing a bar notch (3) in a side of a side member (1) and a cross member notch (4) on an end of a cross member (2), the method comprising the steps of:

preliminarily shearing or punching said side member (1) at a first depth (d) from a side surface (1') of said side member (1),

preliminarily shearing or punching said cross member (2) at said first depth (d) from a side surface (2') of said cross member (2), and

secondarily shearing or punching said side member (1) at a second depth (D) from said side surface (1') of said side member (1) to produce said bar notch (3) wherein said bar notch (3) includes a plane bottom (5), which is parallel with said side surface (1') in the side member and two equally long, oblique sides (6), which have oppositely direct equal inclinations in relation to the bottom (5) having an angle of less than 90°, and

secondarily shearing or punching said cross member (2) at said second depth (D) from said side surface (2') of said side member (2) to produce said cross member notch (4), wherein the cross member notch has a plane end (7) in a cross member (2) and two inclined sides (8), wherein said first depth (d) of said preliminary shearing or punching of said side member (1) is less than but similarly oriented to said second depth (D) of said secondary shearing or punching of said side member (1), and wherein said first depth (d) of said preliminary shearing or punching of said cross member (2) is less than but similarly oriented to said second depth (D) of secondary shearing or punching of said cross member (2), whereby said side member can be joined with said cross member by the bar notch (3) fitting into said cross member notch (4).

2. (Withdrawn) Machine for implementation of the procedure according to claim 1, which comprises in top-view a triangular knife head (9) for two side knives (10) and a nose knife (11), which is displaceable in the vertical direction in a guide (12), which can be moved in the horizontal direction towards or away from a workpiece, which is to be processed, and rests against a rest (13) on a table (14), characterised by the fact that the machine is embodied with a first set of adjustable guide members (17), which can adjust the position of the knife head (9) in relation to the workpiece (1) or (2), which is to be processed, exclusively during the shearing operation, with a second set of adjustable guide members (23) for the setting of the distance between the bar notches (3), and with a third guide member (29), which can function as an end stop for a cross member in the process of shearing a cross bar notch (4), and that the table (14) is embodied with an indentation (33) which permits the bottom cutting edge of the two side knives (10) and the nose knife (11) in their bottom position to be level with or slightly lower in relation to the top side of the table (14), and that the indentation (33) is fitted with a dolly (34) of a soft material, for example a synthetic material.

3. (Withdrawn) Machine according to claim 2 characterised by the fact that the first set of adjustable guide members consists of two stops (17) which each is displaceably positioned on a guide rail (18) mounted on the knife head (9) each along its own side knife (10) and which can be fixed to a guide rail (18) in a desired position by means of screws (19) which stops (17) have an internal edge (20), which rests against the outer side of a side knife (10) and a plane front side (21), which can come to rest against the workpiece (1) or (2) which is to be processed, and

which is parallel with the rest (13).

4. (Withdrawn) Machine according to claim 2 characterised by the fact that the rest (13) is embodied as a guide rail with a longitudinal guide list (22) at the rear end, and that the second set of adjustable guide members consists of a number of stops (23), which can be displaced in the longitudinal direction of the 15 rest (13) and can be fixed to it in a desired position by means of a bench screw (24) with a handle, and that the stop (23) is embodied with a swingable arm (28), which from an active position – in which a stop (28') at the end of the arm can come to rest against the end of the workpiece (1) to be processed – can be swung to a passive position.

5. (Withdrawn) Machine according to claim 4 characterised by the fact that the stop (23) at the rear end at the guide list (22) has a lower part (25) with a U-shaped opening (26) to accommodate the bottom edge of the guide list (22), and an upper part (27) embodied as a fork, which in its mounted position 25reaches in over the rest (13) and acts as a guide for the arm (28) in the latter's active position, and that the arm (28) is swingably hinged to the upper part (27) at a stud (28').

6.(Withdrawn) Machine according to claim 2 characterised by the fact that the rest (13) consists of two parts, a right-hand part (13') and a left-hand part (13''), which off the centre of the knife head (9) are placed at a mutual distance (a), and that the third guide member consists of a catch (29), which can be made of square-bar steel and which can be displaced crosswise to the rest (13) in a guide (30), which is mounted on the table (14) in the space (a) from a forward processing position in which the catch (29) projects a distance forward of the front edge (31) of

the rest (13), and where it serves as a rest for the end of a bar (2) during the punching of a cross member notch (4), to a retracted passive position, and that the catch (29) can be fixed to the table (14) by means of a clamping arrangement (32).

7. (Withdrawn) Machine according to claim 2 characterised by the fact that the dolly (34) is detachably mounted on a plate (35).

8. (Withdrawn) Machine according to claim 2 characterised by the fact that the nose knife (11) is of the same width as the bottom (5) in a side member notch (3).